



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4931-5
Job Sheet 168431



Part No: D4931-5

Job Qty: 6 ea

Part Name: Engine Fitting (for B3e models)



Part Weight: 0 lbs

Job Created: 11/14/17

Due Date: 12/6/17

Type: SOLD

Status: Scheduled

Priority: High

Job Tracking No:

Created By: Linda Lacelle

Description:

Note: DWG REV A SHEET 3 IPP REV:A NEW ISSUE 13-09-16 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	12/5/17	12/5/17	0.00	0.00	Start Up Machining		
100	Doosan	6 pcs	12/5/17	12/5/17	0.78	5.22	Doosan		
110	QC	6 pcs	12/5/17	12/5/17	0.00	0.00	QC2		
112	Mill Conv	6 pcs	12/6/17	12/6/17	0.00	2.48	Mill Conv 1		J.C. - L. 17-12-06
115	QC	6 pcs	12/6/17	12/6/17	0.00	0.00	QC2		J.C. - L. 17-12-06
120	QC	6 pcs	12/6/17	12/6/17	0.00	0.00	QC8		J.L. 17-12-7
130	Packaging	6 pcs	12/6/17	12/6/17	0.00	0.00	Packaging3		AT
140	QC21-SA	6 Ea	12/6/17	12/6/17	0.00	0.00	QC21		

Part Op 100 - Machine as per folio FB210
Descriptions: 112 - DRILL HOLES AS PER REQUIRED

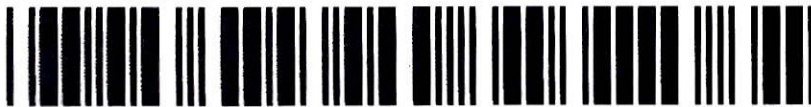
DAS
77
S/LD
DEC 07 2017

Job Allocations

DART
AEROSPACE
S016773

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Std Qty
0



Engine Fitting (for B3e models)

1 dart.leroux.jason

PART NO: D4931-5
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 12/04/17
Job No: 168431

DART AEROSPACE LTD		Work Order: 168431
Description: EAPS P2 Engine Fitting		Part Number: D4931-5
Inspection Dwg: D4931	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1-1/16-12 UN 2A	N/A	1 1/16-12	✓			
37°	+/-0.5°	37°	✓		Protractor	
0.185	+/-0.010	.185	✓		vern L P28	
0.315	+/-0.010	.312	✓			
0.424	+/-0.010	.424	✓			
0.250	+/-0.010	.250	✓			
0.938	+/-0.010	.943	✓			
1.927 Ref	+/-0.010	1.932	✓			
0.25	+/-0.030	.254	✓			
0.13	+/-0.030	.129	✓			
0.907	+/-0.010	.907	✓			
0.078	+/-0.010	.0775	✓			
Ø0.063	+0.004/-0.001	.063	✓		gauge pin	
0.13 x 45°	+/-0.030 x +/-0.5°	Ø0.13 x 45°	✓		vern L P08	
Ø0.34	+/-0.030	.335	✓			
Ø0.25	+/-0.030	.250	✓			
Ø0.238	+0.005/-0.001	.239	✓		caliper	JCL-08
35°	+/-0.5°	35°	✓		Protractor	
0.532	+/-0.010	.532	✓		vern L P06	
1.063	+/-0.010	1.063	✓		Caliper	JCL-08
0.513	+/-0.010	0.512	✓		"	
0.749	+/-0.010	.750	✓		vern L P06	
1.025	+/-0.010	1.025	✓		Caliper	JCL-06

Measured by: [Signature]	Audited by: SL	Preliminary Approval:
Date: 17-02-04	Date: 17-12-7	Date:
Rev	Date	Change
A	14.06.24	New Issue
Revised by: KJ		Approved: [Signature]